

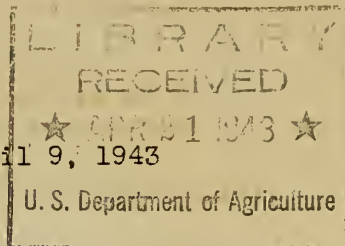
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UNITED STATES DEPARTMENT OF AGRICULTURE  
U.S. Food Distribution Administration  
Washington, D. C.



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FIBER CANS FOR OVERSEAS SHIPMENT

The following spiral and convolute cans shall be used for all products purchased for export by FDA. The type to be used will be stipulated in the announcement.

I. SPIRAL WOUND FIBER CANS:

a. Composite construction, round fiber body and metal ends.

b. Body Construction:

Body construction, round, spiral wound. From inside to outside, one ply of laminated glassine with not less than five pounds waxy laminating agent per ream adhered to chipboard with vegetable adhesive, adhered to chipboard with vegetable adhesive, adhered with an even and continuous film of asphalt laminated kraft, adhered with an even and continuous film of asphalt to asphalt laminated kraft. Laminated glassine to be overlapped approximately 1/8". Chipboard plies to be abutted, asphalt laminated kraft plies to be overlapped approximately 1/4".

The chipboard shall have at least a No. 3 finish and a basis weight in accordance with caliper and finish as shown in "Standard, Weights and Finishes adopted July 1, 1934, by the National Paperboard Association." Asphalt laminated kraft shall consist of two sheets kraft paper, each having a basis weight of not less than 20# combined with not less than 25# (basis weight) of asphalt applied in a uniform and continuous film between the two layers of paper. Asphalt shall be a neutral petroleum pitch or blend free from water soluble material and essentially odorless.

II. MOISTUREPROOF CONVOLUTE FIBER CANS:

Body: Square, oblong ( or round, if specified) convolutely wound.

a. Three or more turns or plies of a special laminated board. This board shall consist of a chipboard of No. 3 finish or better or kraft of an equivalent finish and strength, combined to a glassine (not less than 20 lb. per ream and with a minimum average turpentine penetration test of not less than 600 seconds) with not less than 12" per ream of 3000 sq. ft. of a waxy laminating agent applied as a uniform and continuous film. The body is to be wound with the glassine on the inside.

b. A lining turn or ply of a triple laminated sheet overlapped at least 1/2" and adhered to itself. This sheet shall consist of 3 plies of each not less than 20# basis weight combined with not less than 5# of waxy laminating agent at each interface. The laminating agent shall be applied as a continuous and uniform film. The center and one other sheet of this structure shall be glassine having at least 600 seconds minimum average turpentine penetration. The other sheet shall be at least a high super calendered finish paper and shall not show stain as a result of the combining operation and shall be the side which is adhered to the chipboard (or Kraft of equiva-

lent strength) body stock. This chip or Kraft packing shall consist of a sufficient number of plies to meet wall thickness specifications.

### III. ENDS (FOR SPIRAL AND CONVOLUTE CANS):

Unless tinplate is specified, ends shall be made from bonderized black plate carrying a minimum of 2.5 milligrams per square inch (dry film wt.) of sanitary lacquer or enamel having no residual odor. Top shall be so constructed as to provide satisfactory closures by means of a full friction plug. Ends shall be applied to can sidewall by means of a double crimp or, as frequently referred to in the industry, a "false" double seam. When there is no provision for reclosure bottom shall be seamed on by a can maker, and top shipped loose and applied after filling. Provision for the type of closure will be included in the announcement requesting offer of commodity.

Plugs: The friction plug shall have a hemmed or curled edge and shall be a proper size and construction in relation to the throat of the can top to permit a uniform tight fit around the periphery, accomplishing a moisture vapor tight closure and one which will not loosen under severe shipping condition. The minimum depth of the plug draw shall be 1/4".

Wall Thickness, Metal Weights, Counter Sink, and Seam Depth: Cans shall conform to the minimum requirements shown in the following table:

Area Can Base in Sq. in.	Ends		Caliper			
	<u>Gage of Metal</u> Bottom Ring & Plug		Counter Sink	Depth of Seam	Spiral Wound Ply Thickness	Convolute Wound Wall Thickness
Up to 7"	34	32	1/8"	3/32	.016	.036
7 to 15"	32	31	9/64"	7/64	.019	.045
15" to 28"	31	31	5/32"	1/8	.019	.160
Above 28"	30	30	1/4"	7/32	.025	For Spiral Cans Only

### IV. LABELS (Convolute Cans):

Convolute cans shall be labeled with a waterproof duplex kraft of not less than 50# basis weight (25 x 38 - 500) having a pasted overlap of not less than 3/16". Labels to be printed with information required by the Pure Food and Drug Law.

### LABELS (Spiral Cans):

Spiral cans may be printed or imprinted on the finishing ply or added in the form of a spot label.

### Note: Ratio Can Dimensions:

Circumstances may arise in which can may be ordered without specifying dimensions, merely calling for designated cubic capacity. Where dimensional



details are left to the discrimination of the manufacturer, he should maintain reasonable and sound proportions in the ratio of the can height to the area of the base. The height should be neither inordinately great in proportion to the base dimensions, nor should it be unreasonably small, resulting in a disproportionately squat can.

## V. SPICES:

### A - Non-Oily - in closed top cans.

Size: Oblong or square base of standard commercial dimensions and height, eliminating any unnecessary headspace.

Body: 3 or more plies or board with a Mullen test not less than #3 finish chipboard convolutely wound to a minimum body wall thickness of:

1. 4 ounce size - .030.
2. 8 ounce size - .036.
3. 16 ounce size - .036.

Label: Standard commercial 20-25-20 (or heavier) asphalt laminated kraft paper label, covering the entire body, applied with a vegetable glue and with an overlap of not less than 3/16", overlap to be glued with a waterproof glue. Asphalt shall be a neutral pitch or blend, free from water soluble material, and essentially odorless.

Ends: Top embossed with 5 or more approximately 1/8" punch-outs for sifting. Plain bottom. Standard commercial flange and counter sink. Ends shall be of:

(a) Bonderized black iron, inside sanitary enameled; outside either sanitary enameled or non-lustrous pigmented waterproof coated.

(b) Plain or non-toxic coated recovery tinplate.

(c) Gauge of Ends:

1. 4 ounce size - 34 gauge or heavier.
2. 8 ounce size - 34 gauge or heavier.
3. 16 ounce size - 32 gauge or heavier.

### B - Oily - in closed top cans.

Size: Oblong or square base of standard commercial dimensions and height eliminating unnecessary headspace.

Body: 3 or more plies of greaseproof laminated board convolutely wound. Board shall be laminated with an enamel glue to a greaseproof paper of not less than 25# basis weight.

Body Wall Thickness:

1. 4 ounce size - .030 or heavier.
2. 8 ounce size - .036 or heavier.
3. 16 ounce size - .036 or heavier.

Label: Same as Non-Oily Spices.

Ends: Top embossed with 5 or more approximately 1/8" punch-outs for sifting. Plain bottom. Standard commercial flange and counter sink. Ends shall be made of:

(a) Powderized black iron coated on both sides with a sanitary enamel which is not softened by spice oils.

(b) Recovery tinplate plain or with a non-toxic enamel which is not softened by spice oils.

- Gauge: 4 ounce - 34 gauge or heavier.  
8 ounce - 34 gauge or heavier.  
16 ounce - 32 gauge or heavier.

C - NON-OILY SPICES IN FRICTION TOP CANS:

Same as Section A except:

Ends: Spoon size or regular size friction plug top.

D - OILY SPICES IN FRICTION TOP CANS:

Same as Section B except:

Ends: Spoon size or regular size friction plug top.